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D2010-104
Job Sheet 196450



Part No: D2010-104

Job Qty: 8 pcs

Part Name: Arm



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/13/19

Job Tracking No:

Due Date: 7/24/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV D IPP A 04.02.17 New issue KJ/JLM IPP Rev:B 08-05-27 as per ECN1195P DD verified by:EC IPP
Rev:C 08-06-20 rev.D as per dwg DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - Brake NC	8 pcs	7/24/19		0.25	2.61	Small Fab - Brake - 1		DAS 58 SEP 11 2019 9-89
							Small Fab - Brake - 2		
							Small Fab - Brake - 3		
110	Small Fab - 2 - B4B	8 pcs	7/24/19		0.00	2.00	Small Fab - 1 - B4B		DAS 58 SEP 16 2019 9-89
							Small Fab - 2 - B4B		
							Small Fab - 3 - B4B		
							Small Fab - 4 - B4B		
							Small Fab - 5 - B4B		
							Small Fab - 6 - B4B		
							Small Fab - 7 - B4B		
120	Small Fab - 3 - B4B	8 pcs	7/24/19		0.00	1.65	Small Fab - 1 - B4B		DAS 58 SEP 16 2019 9-89
							Small Fab - 2 - B4B		
							Small Fab - 3 - B4B		
							Small Fab - 4 - B4B		
							Small Fab - 5 - B4B		
							Small Fab - 6 - B4B		
							Small Fab - 7 - B4B		
130	QC 5	8 pcs	7/24/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		

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				QC 5 - 9		
				QC 5 - 50		DAS
				QC 5 - 30		40
				QC 5 - 40		SEP 16 2019 9-89
140 Powdercoat - 4 Black Sand - B4B	8 pcs	7/24/19	0.00 0.24	Powdercoat - 1 - B4B		
				Powdercoat - 2 - B4B		
				Powdercoat - 3 - B4B		34 19-9-18.
				Powdercoat - 4 - B4B		
150 QC 3	8 pcs	7/24/19	0.00 0.00	QC 3 - 10		
				QC 3 - 13		
				QC 3 - 15		
				QC 3 - 17		
				QC 3 - 18		
				QC 3 - 2		
				QC 3 - 28		
				QC 3 - 3		
				QC 3 - 30		
				QC 3 - 34		
				QC 3 - 36		
				QC 3 - 41		DAS
				QC 3 - 51		81
				QC 3 - 58		9-89
				QC 3 - 59		SEP 18 2019
				QC 3 - 68		
				QC 3 - 9		
				QC 3 - 40		
				QC 3 - 19		
				QC 3 - 43		
				QC 3 - 24		
160 Packaging 3-1 - Stock - B4B	8 pcs	7/24/19	0.00 0.00	Packaging 3 - 1 - B4B		
				Packaging 3 - 2 - B4B		
				Packaging 3 - 3 - B4B		ST 351
				Packaging 3 - 4 - B4B		
				Packaging 3 - 5 - B4B		
				Packaging 3 - 6 - B4B		
				Packaging 3 - 7 - B4B		
				Packaging 3 - 8 - B4B		
				Packaging 3 - 9 - B4B		
				Packaging 3 - 10 - B4B		
				Packaging 3 - 11 - B4B		
				Packaging 3 - 12 - B4B		
				Packaging 3 - 13 - B4B		
				Packaging 3 - 14 - B4B		
				Packaging 3 - 15 - B4B		
				Packaging 3 - 16 - B4B		
				Packaging 3 - 17 - B4B		
				Packaging 3 - 18 - B4B		
				Packaging 3 - 19 - B4B		
				Packaging 3 - 20 - B4B		
				Packaging 3 - 21 -		

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					B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
170 QC 21 - SA	8 ✓ pcs	7/24/19	0.00 0.00	QC 21 - SA - 21 ✓	QC 21 - SA - 70	QC 21 - SA - 53

SEP 18 2019
21
8-89

Part Op 100 - (Punch ends and deburr as per dwg), Punch per Dwg. D2010-104 and Spec Control Dwg D2727 Identify as D2010-Descriptions: 104

110 - 1- Bend as per Dwg D2010 using bending Jig D2010-104T2 2- flare before installing plug as per dwg D2010 3- Install D2057 plug as per Dwg D2010

120 - 1- flare before installing plug as per dwg D2010 2- Install D2057 plug as per Dwg D2010

130 - (QC5- Inspect part completeness to step on W/O)

140 - (Black Sandtex(Ref:4.3.5.7) per QSI005 4.3), START TIME: _____ OVEN TEMPERATURE: _____

150 - (QC3- Inspect Part Finish)

160 - (Identify as per dwg & Stock Location: _____)

170 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304TR0.500W.049	304 Round Tube .500 X .049W	12 ft (1.5 ea)	100-Small Fab - Brake NC	S166227
D2057	Plug	8 pcs (1 ea)	110-Small Fab - 2 - B4B	S119992 S191307

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - Brake NC	M304TR0.500W.049	12	129	0
110-Small Fab - 2 - B4B	D2057	8	4	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Arm	7.900inches ± 0.030	7.930 7.870		
2	Arm	10.200 ± 0.030			
3	Arm	45.000Degree ± 0.500	45.500 44.500		
4	Arm	45.000Degrees ± 0.500	45.500 44.500		
5	Arm	0.600inches + 0.008 - 0.001	0.608 0.599		

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WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

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